

Ship June 27

Work Order ID 69860



Page 1

Friday, May 20, 2011 10:41:08 AM

Item ID:	D3172-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Basket Base Assembly				Stop	
Start Date:	5/20/2011	Start Qty:	1.00			
Required Date:	6/10/2011	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/05/20</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3172	Rev C

100		0.00
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Large Fab

Large Fab

Large Fab

Memo

- 1-Cut Qty 4 D3166-1 as per Dwg D3172
- 2-Cut 3/4" x 3/4" square tubing as per Dwg D3172
- 3-Drill holes in D3172-3 as per Dwg D3172
- 4-Deburr & Remove all markings from material
- 5-Weld as per Dwg D3172 using Welding Table and corner Jig & D3172T1
- 6- Use DT 8996 jig to locate D3174-1 as per dwg
- 7- Deburr

SAD 11-06-24

CP 11.06.24

Pho-7

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00
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QC

Quality Control

Memo

0.00

11.06.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3172-041 PAR #: W/A Fault Category: Large Defect NCR: Yes No DQA: 1 Date: 11.07.06
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 1 Date: 11/07/06

NCR: <u>69860</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/06/21</u>	<u>100</u>	Found after welding that the position of D3174-1 on the RBS (D3166-1) 3/4" off. Re. welding sig on used correctly / Lock up training	<u>11.06.27</u> <u>031042</u> <u>4.2.6</u>	Scrap + Destroy Qty +2 D3166-1 + Qty +4 D3174-1. Rephr D3166-1 B <u>70188</u> DB174-1 B <u>69935</u>	<u>11.06.24</u>	<u>11/06/27</u>	<u>11.06.27</u>	<u>11/06/21</u>
				scrap weld on per as 2004 <u>11/15/28</u>	<u>11.06.24</u>			<u>11/06/21</u>

NOTE: Date & initial all entries

Work Order ID 69860

Friday, May 20, 2011 10:41:08 AM



Page 2

Item ID: D3172-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Base Assembly

Start Date: 5/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

8 w/6/23



QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

X ϕ M-L 11/06/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Page 3

Accept

Setup Start

Stop

**Cust Item ID:**

Required Date: 6/10/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Stop

**Insp.
Stamp**

0.00

Powdercoat

Powder Coating

Memo

1ST COAT:

START TIME:

OVEN TEMPERATURE: _____

FINISH TIME:

*****2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

05

0.00

0.00

140



QC

Quality Control

QC3- Inspect Part Finish

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69860

Friday, May 20, 2011 10:41:09 AM



Page 4

Item ID: D3172-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Base Assembly

Start Date: 5/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: *6-A*

0.00



Packaging

Memo

*w/o
66660*

0.00

Packaging

ES 11/06/27

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/6/27**11/11/06/27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, May 20, 2011 10:41:05 AM

Page 1

Work Order ID: 69860

Parent Item: D3172-041

Parent Item Name: Basket Base Assembly





Start Date: 5/20/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 04.01.05 Added Step 5 inspection KJ/RF
IPP Rev:C 08-08-29 revC as per dwg DD verified by:EC IPP Rev:D
11.04.04 added pressure wash DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2012-117  Clevis		Manufactured	No			100	Each	20.0000	2	2			
<div> <div>Location</div> <div>WA005</div> <div>55729</div> </div> <div> <div>Loc Qty</div> <div>20</div> <div>20</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2232-3  Basket Hinge		Manufactured	No			100	Each	16.0000	2	2			
<div> <div>Location</div> <div>WA005</div> <div>69211</div> </div> <div> <div>Loc Qty</div> <div>16</div> <div>16</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2327-3  Spacer Bushing		Manufactured	No			100	Each	19.0000	2	2			
<div> <div>Location</div> <div>WA</div> <div>69436</div> </div> <div> <div>Loc Qty</div> <div>19</div> <div>19</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2581  Mounting Bracket		Manufactured	No			100	Each	54.0000	2	2			
<div> <div>Location</div> <div>WA</div> <div>68964</div> <div>69258</div> </div> <div> <div>Loc Qty</div> <div>54</div> <div>26</div> <div>28</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													

Pl 11.06.24

Pl 11.06.24

Pl 11.06.24

B70724 → 2

Pl 11.06.24

B69739 → 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, May 20, 2011 10:41:06 AM

Page 2

Work Order ID: 69860



Parent Item: D3172-041



Parent Item Name: Basket Base Assembly

Start Date: 5/20/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00

D3166-1

Manufactured No

100 Each

2.0000

4

4



Basket Hoop



P/L 11-06-24

Location

Loc Qty

Loc Code

WA

2

66719

2

D3174-1

Manufactured No

100 Each

12.0000

8

8



Mounting Lug



B70188 -> (4) (16)

P/L 11-06-24

Location

Loc Qty

Loc Code

WA005

12

66816

12

M304EX0.75-16F

Purchased No

100 sf

506.2978

48

48



Expanded Metal Flat SS



369935 -> (8) (16)

SAD 11-06-23

Location

Loc Qty

Loc Code

MAT

209.1053

117708

209.1053

WA

297.1925

115012

114

117197

167.1584

117455

16.0341

117 896

48.0

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Friday, May 20, 2011 10:41:06 AM

Page 3

Work Order ID: 69860

Parent Item: D3172-041

Parent Item Name: Basket Base Assembly

Start Date: 5/20/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.065

Purchased

No

100

f

1,321.290

51

53.68421



304 SQ Tube .75x.75x.065W



SAN 11-06-20

Location

Loc Qty

Loc Code

MAT018

1140.8565

117598

1000

117636

140.8565

WA007

180.4339906

116267

162.707172

116763

17.7268186

53.6843 + 2.000 = 55.6843

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

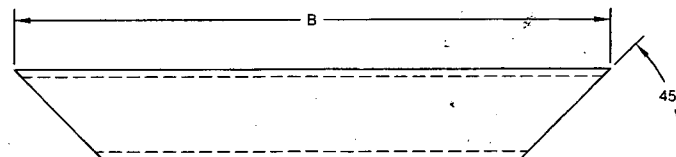
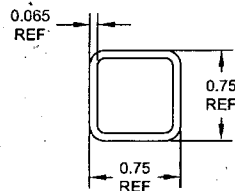
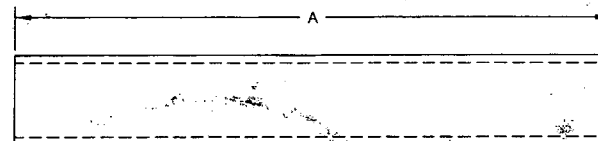
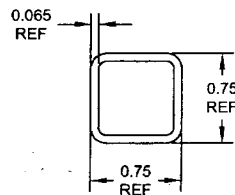
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PARTS LIST FOR D3172-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3172-1	2	—	96.00	RIB
D3172-3	2	—	25.50	RIB
D3172-5	6	33.09	—	RIB
D3172-7	3	26.81	—	RIB
D3172-9	1	94.50	N/A	RIB
D2012-117	4	N/A	N/A	CLEVIS
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D3166-1	4	N/A	N/A	RIB
D3174-1	8	N/A	N/A	MOUNTING LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69860
CL11/05/20



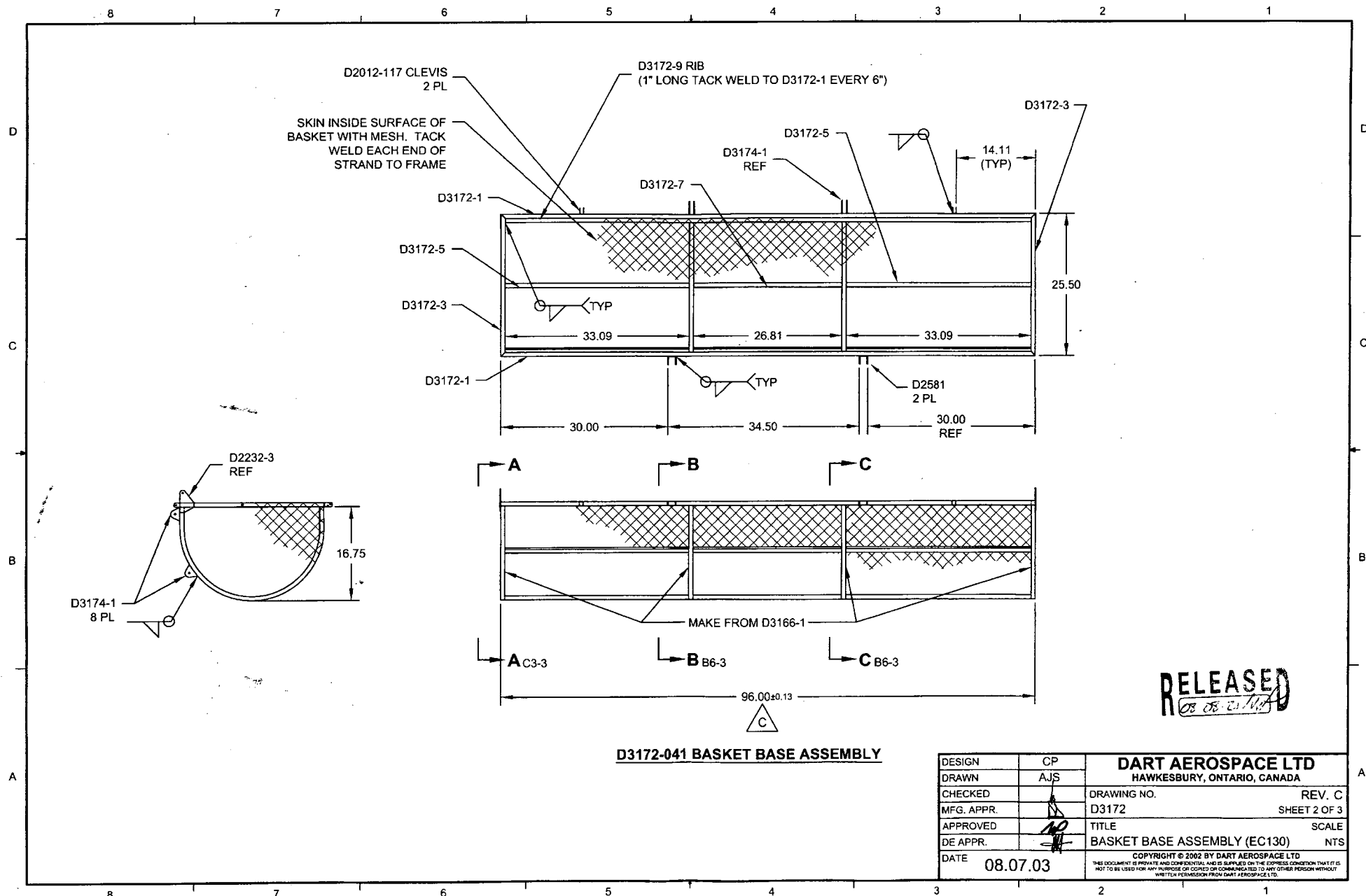
RELEASED
08.07.03



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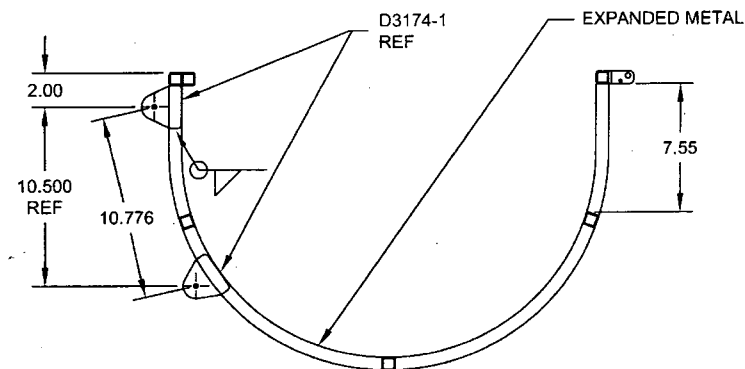
- MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- MESH MATERIAL: 3/4-16F EXPANDED SS
REF. DART SPEC M304EX0.75-16F
- FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: NONE
- WEIGHT: N/A
- WELD PER DART QSI 004

C	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.03
B	ADD D3172-9 & D2012-117	CP	03.01.07
A	NEW ISSUE	DS	02.12.02
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3172	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (EC130)	NTS
DATE	08.07.03	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



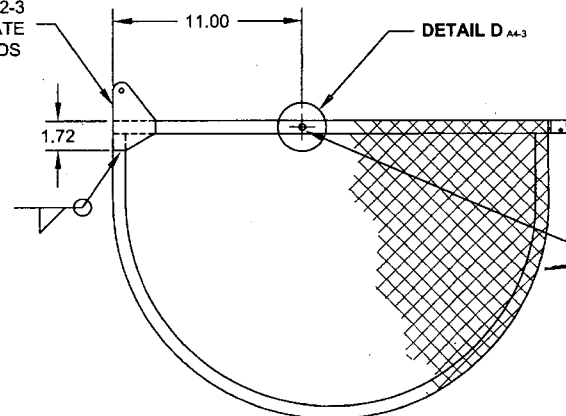
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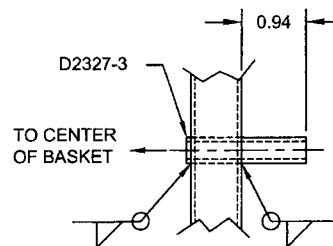


**SECTION B-B^{B5-2}
AND SECTION C-C^{B3-2}**
RIB DETAIL
SCALE 2X

D2232-3
HINGE PLATE
BOTH ENDS



SECTION A-A^{B5-2}
SPACER DETAIL
SCALE 2X



DETAIL D^{D3-3}
SCALE 4X

RELEASED
08.08.21/1140

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3172	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (EC130)	NTS
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8 7 6 5 4 3 2 1

A